



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

649.5301

Job Sheet 186022



Part No: 649.5301

Job Qty: 4 ea

Part Name: Lower Deflector Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 11/29/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 13.09.08 NEW ISSUE DD VERF:JLM IPP REV:B 14.12.02 AS PER DWG REV C1 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/29/18	11/29/18	0.00	0.00	Start Up Stores/Pkg-1	9-89	NOV 13 2018
110	Packaging	4 pcs	11/29/18	11/29/18	0.00	0.00	Packaging1-1	9-89	NOV 13 2018
120	Small Fab	4 pcs	11/29/18	11/29/18	0.00	0.29	Small Fab-1	9-89	NOV 13 2018
130	QC	4 pcs	11/29/18	11/29/18	0.00	0.00	QC5	9-89	NOV 13 2018
140	Packaging	4 pcs	11/29/18	11/29/18	0.00	0.00	Packaging3-1	9-89	NOV 13 2018
150	QC21-SA	4 Ea	11/29/18	11/29/18	0.00	0.00	QC21	9-89	NOV 13 2018

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note . A/R RTV LOCTITE 598:
Descriptions: exp. date:

140 - ***IDENTIFY AS PER IAW MPP-120***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
649.5310	Lower Deflector	4 Ea (1 ea)	90-Start up Operation	127886
649.5312	Breakaway Tip	4 Ea (1 ea)	90-Start up Operation	12731023 F136121
MS20470AD6-14	Rivet	8 Ea (2 ea)	90-Start up Operation	FM13664-4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	649.5310	4	5	0
	649.5312	4	9	0
	MS20470AD6-14	8	299	0



Container No: S127449



Part: 649.5301

Job No: 186022

Serial No/Batch: S127449

Revision:

Inspector:

Exp Date:

Instructions:

Date: 11/13/18

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

ns

be found.

Plex 11/8/18 10:24 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

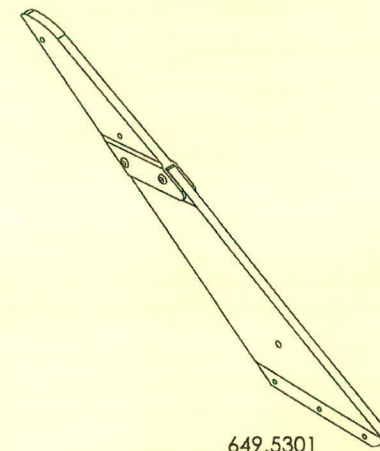
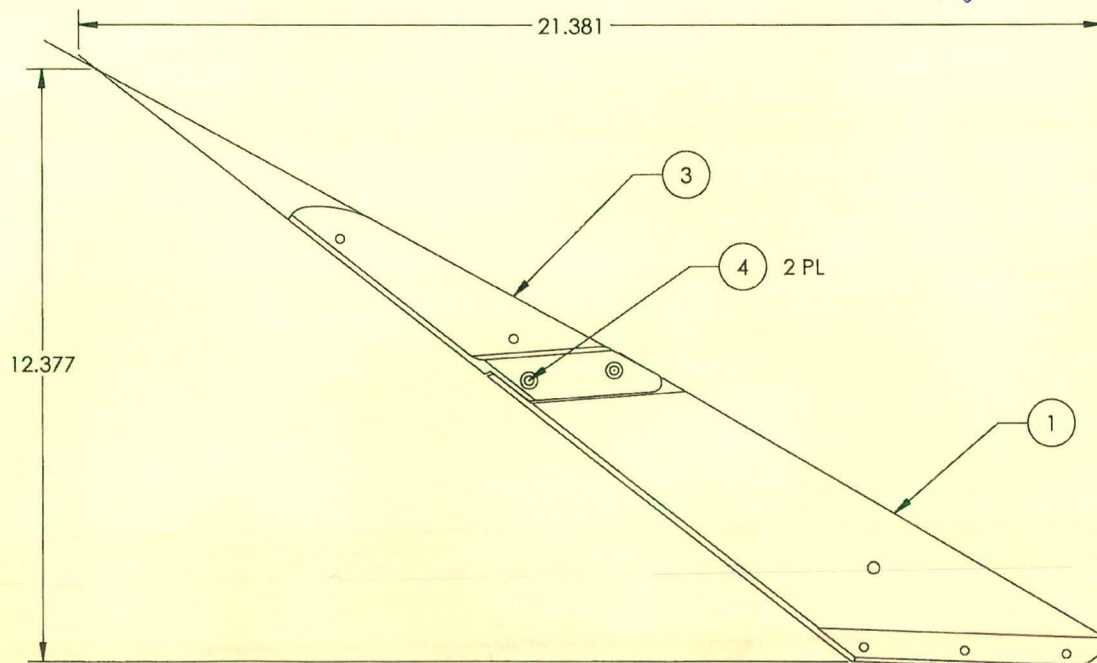
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- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAQ MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
PRE TREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIMER IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 DEBURR AND BREAK ALL SHARP EDGES
- 4 IDENTIFY IAW MPP-120
- 5 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 & 3 UPON ASSY

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WITHOUT NOTICE
WORK ORDER

NO. 186022 MW
18-11-09

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PRT		N/A
N/C	INITIAL RELEASE	12-04-11	P. BRAVO
A	INCORPORATED ECH2 03413, 03421 AND 03486	04-16-12	P. BRAVO
B	INCORPORATED ECH 03523	05-23-12	P. BRAVO



A/R	5	601.2045	RTV, LOCTITE 598		5
2	4	601.3074	RIVET	MS20470AD6-12	
1	3	649.5312	BREAKAWAY TIP		1/2
	2	649.5311	UPPER DEFLECTOR		1/2
1	1	649.5310	LOWER DEFLECTOR		1/2
		649.5301	LOWER DEFLECTOR ASSY		
.5301	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE 12-04-11	APICAL INDUSTRIES
649.4900		DRAWN BY A. GUAN	2608 TEMPLE HEIGHTS DR.
		CHECKED BY P. BRAVO	OCEANSIDE, CA. 92056-3512 (760)724-5300
		DRAWING APPROVAL P. BRAVO	DEFLECTORS
		CONTRACT NO.	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.02 3 PLACE DECIMALS ±.010 ANGLES ±.5°	SHEET NO. 07M26 DWG. NO. 649.5300 REV. B
		SCALE NONE	SHEET 1 OF 4

Linda Lacelle

From: Linda Lacelle
Sent: Wednesday, November 7, 2018 11:21 AM
To: Patrick Duval; Caitlin Crooks
Cc: Jason Leroux; Jean-Luc Menard; Marc Bellavance
Subject: RE: 649.4701- rev C
Attachments: 649.4900 A1 CUTTER ASSY.pdf

Thx Pat
Pls see below

From: Patrick Duval
Sent: Tuesday, November 6, 2018 5:43 PM
To: Caitlin Crooks <ccrooks@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>
Subject: RE: 649.4701- rev C

Linda,
Here's a quick list of what I will need in order to make my kit to rev C.

649.5111 need some at rev A1 (got some in quarantine) – are these good to use?
649.5112 need some at rev A1 (got some in quarantine) – are these good to use?
649.4811 need some at rev A – WJ>OS – approx. 3wks
649.4816 need some at rev A – WJ>OS – approx. 3wks
649.4813 need some at rev A – WJ>OS – approx. 3wks
649.5214 need some at rev A – Machining>OS- approx. 4-5wks aro
649.5010 need some at rev C1 – Machining>OS- approx. 4-5wks aro
649.4902 need some at rev A – do the 649.5301 and 649.8301 need to be at an older rev? see attached

x 4 each

Rev A1

Also for me to complete the kit from RA173 we will need to add, remove some of the hardware to make it as per rev C.

Sorry for the delay... this is a big mess and I don't what to rush and ship something that's not good.

Pat Duval
QC Coordinator

